

Work Order ID 117751

Thursday, May 01, 2014 10:37:18 AM

117751

Page 1

Item ID: D412-694-03

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Hinge Door Assembly, LH

Stop ***NS2***

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-05-01 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D412-694	Rev C1

100 Document Control 0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Issue red decal labels for D412-694-03. CHG005

MLS 14-12-23

110 COMPOSITE ASSEMBLY 0.00

110

Small Fab

Memo

0.00

Small Fab

D412-694-03 Drill Process1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/-T6 as per Dwg D412-694 page 3.Note: Ensure slot is aligned wi

ST 14-12-17

120 COMPOSITE ASSEMBLY 0.00

120

Small Fab

Memo

0.00

Small Fab

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).2- Sand flush excess Hysol around the insert on both doors.

ST 14-12-17

DQA:

Date:

15/03/25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/03/24

Work Order update only ☐

Work Order: <u>117751</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D412 694.03</u>	Rework <input checked="" type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/>	
NCR No. <u>15-4707</u>	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-12-22	60	x2	use 2 AN960508L washers to install 03147-1 pin instead of AN960508L and AN960508LL x1 AN960508LL doesn't exist R.C. Drawing	A.P. 14.12.22	AN960508L/AN511490N8165 M128057 x2 Replace w/	BT 14-12-22	DAS 9 9-89 14-12-24	DAS 9 9-89 14-12-24
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions	Pressure/Forced
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread		
<input type="checkbox"/> Inspection Strip in Tube	<input checked="" type="checkbox"/> Drawing	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function			

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14-12-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width:33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width:33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width:33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 117751

Thursday, May 01, 2014 10:37:18 AM

117751

Page 3

Item ID: D412-694-03

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

Small Fab

COMPOSITE ASSEMBLY

0.00

Memo

0.00

D412-694-03 Assembly Process1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3

14-12-23

170

170

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Install door on mock up helicopter to insure proper fit and function.

14-12-24DAS
9
8-89

180

180

Small Fab

Small Fab

0.00

Memo

0.00

(Put red label inside before putting the cover D3119-041/or Vip trim)1- Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

14-12-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 117751

Thursday, May 01, 2014 10:37:18 AM

117751

Page 4

Item ID: D412-694-03

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: CA2	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89

21 **14-12-24**

MCS **14-12-24**

14-12-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 1

Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A 05.12.09 New Issue KJ/RF
 IPP Rev: B 06.04.18 New dwg rev. ecn781 EC
 IPP Rev: C 06.07.11 Revised per B24660 KJ
 IPP Rev:D 08-08-27 replace QC5 to QC14 seq.7 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
80-005-2-8		Purchased	No			160	Each	270.0000	21	21			
80-005-2-8									**	129790		DAS 86 9-89	
Insert													

Location	Loc Qty	Loc Code
ST380	270	
113109	23	
120273	47	
121500	100	
122661	100	

ALS4-632-80

Purchased

No

160

Each

119.0000

10

10

180673

DAS
86
9-89

Insert

Location	Loc Qty	Loc Code
ST280	119	
112495	119	

AN525-10R7

Purchased

No

160

Each

1,465.000

4

4

DAS
86
9-89

AN525-10R7

SCREW

Location	Loc Qty	Loc Code
ST344	2	
m127447	2	
ST505	1463	
m127815	713	
m128429	750	

4

Picklist Print

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Page 2

Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

BSP45 Purchased No 160 Each 477.0000 34 34

DAS

RSP45

**

130851

66

Commercial Rivet

9-89

Location

Loc Qty

Loc Code

ST282

477

120417

477

BSP46 Purchased No 160 Each 251.0000 12 12

RSP46

**

DAS

Commercial rivet

66

9-89

Location

Loc Qty

Loc Code

ST282

251

112540

251

D3110-1 Manufactured No 160 Each 2.0000 1 1

D3110-1

**

122948

DAS

Escutcheon

66

9-89

Location

Loc Qty

Loc Code

ST026

2

52448

2

D3110-3 Manufactured No 160 Each 1.0000 1 1

D3110-3

**

124704

124104

DAS

Handle Assembly

66

9-89

Location

Loc Qty

Loc Code

ST025

1

114022

1

D3111-041 Manufactured No 160 Each 114.0000 1 1

D3111-041

**

14-12-19

Plate Assembly

Location

Loc Qty

Loc Code

Mezz

114

1053617

114

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3112-1 Manufactured No 160 Each 10.0000 2 2

✓ ***D3112-1***

Guide

Location Loc Qty Loc Code

ST026 10

113503 2

113701 8

D3113-1 Manufactured No 160 Each 7.0000 1 1

✓ ***D3113-1***

Spring

Location Loc Qty Loc Code

ST026 7

36725 7

D3114-1 Manufactured No 160 Each 5.0000 1 1

D3114-1

Pivot

Location Loc Qty Loc Code

CA 5

36726 5

D3116-11 Manufactured No 160 f 70.0000 1.5 2

✓ ***D3116-11***

Seal (\$Per Foot)

Location Loc Qty Loc Code

ST414A 70

27241 62

57494 8

DAS
06
9-89

DAS
06
9-89

✓ 14-12-19

DAS
06
9-89

Picklist Print

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Page 4

Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3116-5 Manufactured No 160 f 110.0000 5.67 6

D3116-5

Seal(\$Per Foot)

068

**

IFT 14-12-19

Location

Loc Qty

Loc Code

ST414A

110

27208

110

XC

D3119-041 Manufactured No

160 Each

3.0000

1

1

D3119-041

Cover Assembly

**

NA aspen w/o 126055 VIP trim installation

Location

Loc Qty

Loc Code

ST107

3

103946

3

D3120-1 Manufactured No

160 Each

3.0000

1

1

D3120-1

Cover

**

Location

Loc Qty

Loc Code

ST236A

3

50531

3

1

D3120-3 Manufactured No

160 Each

7.0000

1

1

D3120-3

Cover

**

Location

Loc Qty

Loc Code

ST236B

7

50315

1

66219

6

1

DAS

06

9-09

NOV 23 2014

DAS

06

9-09

Picklist Print

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Page 5

Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3125-1	Manufactured	No	160	Each	33.0000	1	1
---------	--------------	----	-----	------	---------	---	---

D3125-1

Lever Assy

BT 14-12-19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA	33	
----	----	--

1053617	33	
---------	----	--

X 1

D3125-3	Manufactured	No	160	Each	96.0000	1	1
---------	--------------	----	-----	------	---------	---	---

D3125-3

Lever

BT 14-12-19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA	96	
----	----	--

1053617	96	
---------	----	--

X 1

D3125-7	Manufactured	No	160	Each	79.0000	1	1
---------	--------------	----	-----	------	---------	---	---

D3125-7

Lever

BT 14-12-19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA	79	
----	----	--

1053617	79	
---------	----	--

X 1

D3129-1	Manufactured	No	160	Each	235.0000	2	2
---------	--------------	----	-----	------	----------	---	---

D3129-1

Lever

BT 14-12-19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

Mezz	235	
------	-----	--

1053617	235	
---------	-----	--

X 2

D3130-1	Manufactured	No	160	Each	279.0000	2	2
---------	--------------	----	-----	------	----------	---	---

D3130-1

Clevis Base

BT 14-12-19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

Mezz	279	
------	-----	--

1053617	279	
---------	-----	--

X 2

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3131-1 Manufactured No 160 Each 92.0000 1 1

D3131-1

Stop

BT 14-12-19

Location

Loc Qty

Loc Code

Mezz

92

1053617

92

D3134-1 Manufactured No 160 Each 3.0000 1 1

D3134-1

Rod

BT 14-12-19

Location

Loc Qty

Loc Code

CA

3

114406

2

52369

1

D3134-3 Manufactured No 160 Each 1.0000 1 1

D3134-3

Rod

BT 14-12-19

Location

Loc Qty

Loc Code

CA

1

110828

1

D3140-07 Manufactured No 160 Each 0.0000 1 1

D3140-07

Door

BT 14-10-22

D3143-1 Manufactured No 160 Each 18.0000 1 1

D3143-1

Clevis

DAS
66
9-89

Location

Loc Qty

Loc Code

ST028

18

105407

16

90203

2

NOV 29 2014

Picklist Print

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3143-3 Manufactured No

160

Each

0.0000

3

3

D3143-3

Clevis

123614

DAS

D3144-1

Manufactured No

160

Each

0.0000

1

1

D3144-1

Doubler

116619

ET 14-12-19

D3144-105

Manufactured No

160

Each

3.0000

1

1

D3144-105

Doubler

ET 14-12-19

Location

Loc Qty

Loc Code

CA

3

53163

3

D3144-107

Manufactured No

160

Each

11.0000

1

1

D3144-107

Doubler

ET 14-12-19

Location

Loc Qty

Loc Code

CA

11

52616

11

D3145-1

Manufactured No

160

Each

4.0000

1

1

D3145-1

Bracket

Location

Loc Qty

Loc Code

ST028

4

50099

1

60569

3

DAS

66

9-69 NOV 29 2014

Picklist Print

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Page 8

Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3146-1 Manufactured No

160 Each 7.0000 1 1

D3146-1

Hinge Bracket

DAS
06
9-89

Location

Loc Qty

Loc Code

ST028

7

57569

1

60570

6

D3147-1 Manufactured No

160 Each 18.0000 2 2

D3147-1

Pin

DAS
06
9-89

Location

Loc Qty

Loc Code

ST028

18

109122

12

76196

6

D3149-1 Manufactured No

160 Each 53.0000 2 2

D3149-1

Striker Plate

25 14 - 12 - 19

Location

Loc Qty

Loc Code

Mezz

53

1053617

53

D3150-1 Manufactured No

160 Each 3.0000 2 2

D3150-1

Guide

122 760

DAS
06
9-89

Location

Loc Qty

Loc Code

ST028

3

108893

2

86216

1

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3154-1
D3154-1
Key

Manufactured No 160 Each 27.0000 1 1

ET 14 -12-19

Location Loc Qty Loc Code

CA 27

1053617 27

X 1
2

D3157-1
D3157-1
Spacer

Manufactured No 160 Each 282.0000 2 2

Location Loc Qty Loc Code

ST030 282

1053617 282

2
3

D3159-041
D3159-041
Bracket Assembly

Manufactured No 160 Each 28.0000 3 3

Location Loc Qty Loc Code

ST030 28

50391 28

3
1

D3159-043
D3159-043
Bracket Assembly

Manufactured No 160 Each 34.0000 1 1

Location Loc Qty Loc Code

ST030 34

53601 34

1

DAS
06
9-89

DAS
06
9-89

DAS
06
9-89

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

FW10-032	Purchased	No	160	Each	101.0000	16	16	
FW10-032								DAS
WASHER								06
								9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST284	101	
101203	79	
19249	22	

16

FW4-032	Purchased	No	160	Each	63.0000	6	6	
FW4-032								DAS
Washer								06
								9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST284	63	
101203	63	

6

M7885/3-4-4	Purchased	No	160	Each	108.0000	2	2	
M7885/3-4-4								DAS
Rivets								06
								9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST287	108	
108077	108	

2

M7885/3-4-5	Purchased	No	160	Each	77.0000	1	1	
M7885/3-4-5								DAS
Rivet								06
								9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST287	77	
1108	77	

1

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS20392-1C11

Purchased

No

160

Each

62.0000

2

2

MS20392-1C11

Pin

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST333

62

18822

62

2

MS20392-2C11

Purchased

No

160

Each

65.0000

2

2

MS20392-2C11

Pin

**

DAS
06
9-89

Location

Loc Qty

Loc Code

Mezz

65

14149

55

m126329

10

x 2

MS20392-2C15

Purchased

No

160

Each

17.0000

7

7

MS20392-2C15

PIN

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST332

7

m128228

7

ST333

10

m128398

10

10

6

MS21042106

Purchased

No

160

Each

678.0000

2

2

MS210421 06

Nut

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST314

678

m127304

20

m127831

58

m128401

200

m128754

200

m128976

200

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Thursday, May 01, 2014 10:37:17 AM

Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

160

Each

7,815.000

7

7

MS21042L3

130799

Nut

DAS
06
9-89

Location

Loc Qty

Loc Code

ST314

860

M127410

13

M127831

41

M128401

806

ST506

955

123900

955

ST509

6000

M128754

6000

MS24665-151

Purchased

No

160

Each

424.0000

11

11

MS24665-151

Cotter Pin

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

24

17566

24

ST323

400

m128401

400

MS24694-C4

Purchased

No

160

Each

214.0000

2

2

MS24694-C4

SCREW

DAS
06
9-89

Location

Loc Qty

Loc Code

ST300

214

15924

214

Picklist Print

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS24694-S53

Purchased

No

160

Each

339.0000

2

2

MS24694-S53

SCREW

DAS
06
9-89

Location

Loc Qty

Loc Code

ST303

339

113288

1

113359

338

2

MS24694-S56

Purchased

No

160

Each

147.0000

4

4

MS24694-S56

SCREW

DAS
06
9-89

Location

Loc Qty

Loc Code

ST303

147

m126400

47

m128402

100

4
4

MS24694-S60

Purchased

No

160

Each

50.0000

4

4

MS24694-S60

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST322

50

104407

50

4
2

MS25281-R6

Purchased

No

160

Each

79.0000

2

2

MS25281-R6

Clamp

DAS
06
9-89

Location

Loc Qty

Loc Code

ST304

79

19098

79

2

Picklist Print

Thursday, May 01, 2014 10:37:17 AM

Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-06

Purchased

No

160

Each

803.0000

12

12

MS27039-1-06

DAS
86
9-89

Screw

Location

Loc Qty

Loc Code

ST305

803

104289

803

12

MS27039-1-08

Purchased

No

160

Each

2,111.000

6

6

MS27039-1-08

DAS
86
9-89

Screw

Location

Loc Qty

Loc Code

GA

19

m125654

19

ST305

2092

m128636

2092

6

MS35206-231

Purchased

No

160

Each

38.0000

2

2

MS35206-231

DAS
86
9-89

Screw

Location

Loc Qty

Loc Code

ST288

38

11735

38

2

MS35650-305T

Purchased

No

160

Each

93.0000

4

4

MS35650-305T

DAS
86
9-89

Nut

Location

Loc Qty

Loc Code

ST289A

93

11786

93

4

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS51859-7 Purchased No

160 Each

75.0000

3

3

DAS
06
9-89

MS51859-7

Washer

**

Location

Loc Qty

Loc Code

ST290

75

123482

8

M127993

67

3

NAS1149D0316J

Purchased

No

160

Each

1,048.000

29

29

DAS
06
9-89

NAS1149D0316.J

Washer

**

122/51

Location

Loc Qty

Loc Code

ST293

648

M127993

648

ST510a

400

M127956

400

NAS1149D0332J

Purchased

No

160

Each

5,569.000

13

13

DAS
06
9-89

NAS1149D0332.J

Washer

**

130 325

Location

Loc Qty

Loc Code

ST294

569

m128606

569

ST510a

5000

m128612

5000

DEC 17 2014

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

160

Each

4,845.000

8

8

NAS1149D0363.J

Washer

DAS

86

9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

4822

m126319

51

m128429

4771

8

NAS1149DN616J

Purchased

No

160

Each

469.0000

4

4

NAS1149DN616.J

Washer

DAS

96

9-89

Location

Loc Qty

Loc Code

ST293

469

M127726

469

4

NAS1149DN816J

Purchased

No

160

Each

552.0000

2

2

NAS1149DN816.J

WASHER

DEC 17 2014

Location

Loc Qty

Loc Code

ST293

552

m128057

552

2

DAS

96

9-89

Picklist Print

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

160

Each

3,062.000

2

2

NAS1149DN832J

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

MF4

808

M127255

808

ST293

2092

M128948

1000

M127813

92

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

DAS
06
9-89

NAS1169-10L

Purchased

No

160

Each

9.0000

4

4

NAS1169-10L

Washer

Location

Loc Qty

Loc Code

ST296

9

11753

4

120498

5

NAS388-6-8P

Purchased

No

160

Each

54.0000

15

15

NAS388-6-8P

SCREW

DAS
06
9-89

Location

Loc Qty

Loc Code

ST298

54

119716

20

123900

34

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Work Order ID: 117751

117751

Parent Item: D412-694-03

D412-694-03

Parent Item Name: Hinge Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

NAS391B6P

Purchased

No

160

Each

72.0000

16

16

NAS391B6P

Washer

**

129384 X14

DAS
86
3-89

130799

Location

Loc Qty

Loc Code

ST298

72

124605

72

NAS43DD3-40

Purchased

No

130

Each

30.0000

2

2

NAS43DD3-40

Spacer

**

Location

Loc Qty

Loc Code

ST275

30

112933

30

DEC 17 2014

DAS
86
3-89

2

03125-5

1053617 X1

14-12-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other